



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4091-1

Job Sheet 182430



Part No: D4091-1

Job Qty: 30 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/1/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D4091 Rev. A IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	30 pcs	9/7/18	9/7/18	0.00	0.00	Purchasing		AUG 29 2018
110	Packaging	30 pcs	9/7/18	9/7/18	0.00	0.00	Packaging2		AUG 29 2018
130	QC	30 pcs	9/7/18	9/7/18	0.00	0.00	QC6		15-09-04
160	QC	30 pcs	9/7/18	9/7/18	0.00	0.00	QC3 U/A D		
170	Packaging	30 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2		SEP 06 2018
180	QC21-SA	30 Ea	9/7/18	9/7/18	0.00	0.00	QC21		18.09.07

Part Op Descriptions: 100 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

PO 040644 aug 24. 2018 x 40 R L

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.7530 ft (.1251 ea)	100-Purchasing	S106326
D4091-1P	Lug	30 pcs (1 ea)	100-Purchasing	S106325

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2423	4	344	0
	D4091-1P	30	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches $\pm$ 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches $\pm$ 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches $\pm$ 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches $\pm$ 0.010	0.303		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S106327



Part: D4091-1

Job No: 182430

Serial No/Batch: S106327

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/29/18

			0.283	
7	Mounting Lug	0.735Inches $\pm$ 0.010	0.745 0.725	Reference
8	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
9	Mounting Lug	3.700Inches $\pm$ 0.010	3.710 3.690	
10	Mounting Lug	0.625Inches $\pm$ 0.010	0.635 0.615	
11	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Mounting Lug	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter
13	Mounting Lug	0.400Inches $\pm$ 0.030	0.430 0.370	Radius
14	Mounting Lug	2.310Inches $\pm$ 0.010	2.320 2.300	Reference

Plex 8/24/18 9:32 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO040844**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040844
PO Date: 8/24/18
Due Date: 9/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Via: Ground
Pynt Terms: Net 60

Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182438	D3910-1P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	9/28/18	40 pcs	0 pcs	40 pcs	\$17.40/pcs	\$696.00
								40	X	AUG 29 2018			
2	182430	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	9/28/18	30 pcs	0 pcs	30 pcs	\$17.40/pcs	\$522.00
							DAS 61 9-89	30	X	AUG 29 2018			

Grand Total: \$1,218.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

HL

Plex 8/27/18 8:48 AM dart.Lussier.Patrick



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Fax: 613 678 3956

Attention: Walz, Shigi

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K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040844

PO Date: 8/24/18

Due Date: 9/28/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lussier, PatrickPhone:

Via: Ground

Pymt Terms: Net 60

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Special Comments:

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2	182430	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	9/28/18	30 pcs	0 pcs	30 pcs	\$16.10/pcs	\$483.00

Grand Total: \$1,179.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

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A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/24/18 12:46 PM dart.Lussier.Patrick



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 23005
Date: Aug 24, 2018
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040844	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 24, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D3910-1 Crosstube Lug ✓ alodined and painted as per QSI005		Each	40	40 ✓	
D4091-1 Lug as per drawing D4091 Rev.A ✓ alodined and painted as per QSI005		Each	30	30 ✓	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

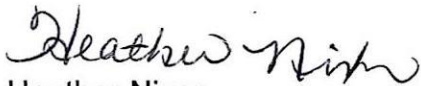
same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
40	D3910-1	Crosstube Lug	160522	22006	40844
20	D4091-1	Mounting Lug	131451	20390	40844
10	D4091-1	Mounting Lug	148835	21095	40844

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, August 27, 2018

DQA: _____ Date: 18/08/30**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>182430</u> Part No. <u>0401-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒																																															
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Date: <u>18-08-30</u>		Step #: <u>130</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-08-30</u>																																																																	
Description Work Order Deviation <u>Quantity of one lug was found w/oppaint sufficient</u>				Disposition <u>Scuff + repaint at DART</u>		Completed By <u>SK 18-9-4</u>																																																																	
						Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-08-30</u>																																																																	
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Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☒</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☒	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>☒ Finish</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	☒ Finish	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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